

Date: Tuesday, 10/06/2008 12:53:56 PM  
 User: Julie Lecocq

## Process Sheet

|  |  |
|--|--|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services  | <b>Drawing Name</b> : 206L UTILITY BASKET                  |
| <b>Job Number</b> : 39779  |  |
| <b>Estimate Number</b> : 11272   |  |
| <b>P.O. Number</b> :   | <b>Part Number</b> : D206540011                            |
| <b>This Issue</b> : 10/06/2008 <b>S.O. No.</b> :   | <b>Drawing Number</b> : D206-540 REV I                     |
| <b>Prsht Rev.</b> : NC   | <b>Project Number</b> : N/A                                |
| <b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY  | <b>Drawing Revision</b> : I                                |
| <b>Previous Run</b> : 36655  | <b>Material</b> :  |
| <b>Written By</b> :  | <b>Due Date</b> : 30/06/2008 <b>Qty:</b> 1 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> : <u>JLD 08.10.10</u>   |  |
| <b>Comment</b> : Est Rev:I Revised per Rev I 05-12-06 JLM<br>Est Rev:H 07-03-20 As per DSI9361 JLM |  |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |    |                  |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



**Comment:** DOCUMENT CONTROL JLD 08.6.11  
 Photocopy bluefile & type labels per PPPD206-540-011 CHG005

508/07/29

|     |             |                       |
|-----|-------------|-----------------------|
| 2.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



**Comment:** PACKAGING RESOURCE #1  
 Pick: Assembly Kit

|     |        |                  |
|-----|--------|------------------|
| 3.0 | 39779A | 206L BASKET BASE |
|-----|--------|------------------|



**Comment:** Sub-Component 206L BASKET BASE  
 1 x D2252-041 Batch 39779A

508/07/24 @

|     |        |                 |
|-----|--------|-----------------|
| 4.0 | 39779B | 206L BASKET LID |
|-----|--------|-----------------|



**Comment:** Sub-Component 206L BASKET LID  
 1 x D2252-043 Batch 39779B

508/07/24 @

|     |          |                               |
|-----|----------|-------------------------------|
| 5.0 | D2332041 | Lid Prop Assembly 6.69" long. |
|-----|----------|-------------------------------|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
 Pick: Assembly Kit  
 Qty Part Number Description Batch  
 1 D2332-041 Prop Ass'y 38797

508/07/24 @

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L UTILITY BASKET

Job Number: 39779

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2022101

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2022-101 SPACER

37521

SS

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment

40211

SS

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring

37071

SS

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing

39153

SS

10.0

D2931

Bumper



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 D2931 Bumper

21139

SS

11.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS20600AD4W3 Rivet

M18071

SS 08/01/24

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L UTILITY BASKET

Job Number: 39779

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN4-7A Bolt M107321

JS

13.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN4-24A Bolt M164547

JS

14.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN3-16A Bolt M167737

JS

15.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN4-22A Bolt M167715

JS

16.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN5-17A Bolt M160815

JS

17.0

AN960JD416 L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD416L Washer M107939

JS 08/12/24

PW

Dart Aerospace Ltd

| W/O:     |      | WORK ORDER CHANGES                     |    |          |     |                                   |                          |
|----------|------|--|----|----------|-----|-----------------------------------|--------------------------|
| DATE     | STEP | PROCEDURE CHANGE                       | By | Date     | Qty | Approval<br>Chief Eng<br>Prod Mgr | Approval<br>QC Inspector |
| 08/07/24 | 172  | add 2 washers AN9605D416 L<br>M 108138 | EP | 08/07/24 | 2   | /08/14/24                         | S 08/07/24               |
|          |      |  |    |          |     |                                   |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L UTILITY BASKET

Job Number: 39779

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer

M107959

JS

19.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer

M108077

JS

20.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD8 Washer

M107650

JS

21.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3)

M107665

JS

22.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4)

M107478

JS 08/07/24

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L UTILITY BASKET

Job Number: 39779

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D2258170

Label - 170 lb



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2258-170 PLACARD

16269

SS

24.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5

Nut (or -5)

M167939

SS

25.0

D27283

Dart Logo Label - large



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Dart Logo label large

Batch: 22553

SS 08/09/24

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D206-540

08/07/24 @

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/24 (H)

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

29.0

D2249041

Fitting Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 d2249-041 bracket

1340486

8/7/29

SC

\* 08/07/24

2

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L UTILITY BASKET

Job Number: 39779

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

D33963

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer

Batch: 36336

31.0

D2259

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2259 Placard 10671

32.0

D2525

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2525 Spacer kit 34506

33.0

D2526

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2526 Bushing 27555

34.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2537 BUSHING 39153

35.0

D2748

Clevis



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2748 Clevis 34511

36.0

D27495

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2749-5 Strut 24157

08/07/23 (K)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Drawing Name: 206L UTILITY BASKET

Job Number: 39779

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

D27497

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2749-7 Strut

26887

38.0

AN421A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-21A Bolt

M11695

39.0

AN45A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

8 AN4-5A Bolt

M106605

40.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-12A Bolt

M105143

41.0

AN517A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN5-17A Bolt

M166815

42.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer

M167939

08/07/23 (K)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Drawing Name: 206L UTILITY BASKET

Job Number: 39779

Part Number: D206540011

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN960JD516 Washer

M167959

44.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4)

M167478

45.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 MS21042L5 Nut

M167939

46.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-540-011

Location: RD

PPP Rev: H

8/7/29

Q

Scd

48.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/30

Job Completion



mf 08-07-30



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

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QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries





|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br><b>CB</b>           | DRAWN BY<br><b>CB</b>          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>DSI 9361                           | REV. A<br>SHEET 1 OF 1 |
| DATE<br>07.03.15              |                                | TITLE<br>UTILITY BASKET SPACER                    | SCALE<br>NTS           |
| A                             | 07.03.15                       | NEW ISSUE   |                        |

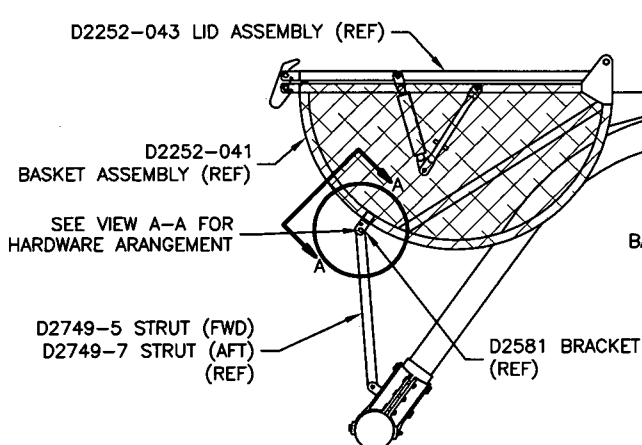
## DART SERVICE INSTRUCTION

TO AMEND DART INSTALLATION DRAWING D206-540 REV. I  
REF. CANADIAN STC: SH94-5  
REF. FAA STC: SR00386NY

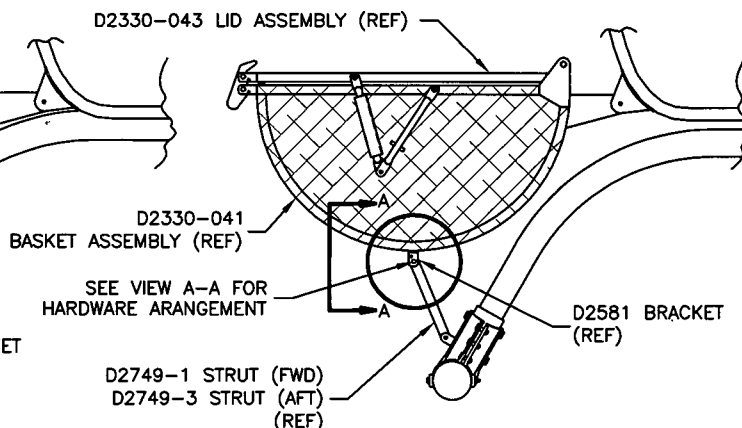
The following parts will be **added** to the Parts List on page 1 of Installation Drawing D206-540.

| Qty -<br>011 | Qty -<br>013 | Part No.     | Description                         |
|--------------|--------------|--------------|-------------------------------------|
| X            |              | D206-540-011 | BASKET INSTL'N - BELL 206L/L1/L3/L4 |
|              | X            | D206-540-013 | BASKET INSTL'N - BELL 206A/B        |
| 4            | 4            | D3396-3      | SPACER                              |

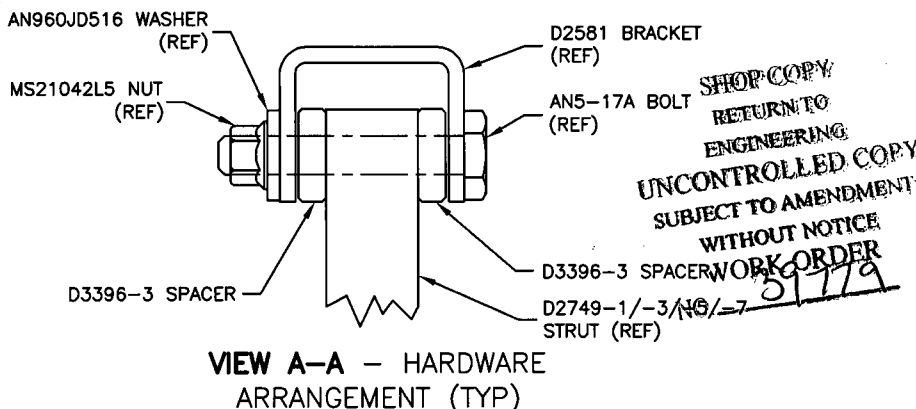
Install qty(2) D3396-3 Spacers per strut at the location shown in **Figure 1** (for D206-540-011 kit) and **Figure 2** (for D206-540-013 kit). Install hardware per View A-A



**FIGURE 1 - D206-540-011  
INSTALLATION**



**FIGURE 2 - D206-540-013  
INSTALLATION**



**VIEW A-A - HARDWARE  
ARRANGEMENT (TYP)**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 07.03.15  
CERT. NO.: SH94-5  
ISSUE NO.: 4

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Date: Tuesday, 10/06/2008 12:54:05 PM  
 User: Julie Lecocq

## Process Sheet

|                                    |   |                           |                  |
|------------------------------------|---|---------------------------|------------------|
| <b>Customer</b> :                  | CU-DAR001 Dart Helicopters Services         | <b>Drawing Name</b> :     | 206L BASKET BASE |
| <b>Job Number</b> :                | 39779A                                      |                           |                  |
| <b>Estimate Number</b> :           | 11273                                       |                           |                  |
| <b>P.O. Number</b> :               |   | <b>Part Number</b> :      | D2252041         |
| <b>This Issue</b> :                | 10/06/2008                                  | <b>S.O. No.</b> :         |                  |
| <b>Prsht Rev.</b> :                | NC  | <b>Drawing Number</b> :   | D2252 REV E      |
| <b>First Issue</b> :               | / /   | <b>Project Number</b> :   | N/A              |
| <b>Previous Run</b> :              | 36655A                                      | <b>Drawing Revision</b> : | E                |
| <b>Written By</b> :                |   | <b>Material</b> :         |                  |
| <b>Checked &amp; Approved By</b> : | JLD 08.6.10                                 | <b>Due Date</b> :         | 30/06/2008       |
| <b>Comment</b> :                   | Est Rev:1 Revised as per Rev E 05-12-06 JLM |                           |                  |

Qty: 1 Um: Each

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |        |             |
|-----|--------|-------------|
| 1.0 | D31661 | Basket Hoop |
|-----|--------|-------------|



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

|     |         |             |         |
|-----|---------|-------------|---------|
| Qty | Part#   | Description | Batch   |
| 5   | D3166-1 | Hoop        | B 40090 |

SAD 08/07/10

|     |                |                          |
|-----|----------------|--------------------------|
| 2.0 | M304TS0750W065 | 304 SQ Tube.75x.75x.065W |
|-----|----------------|--------------------------|



Comment: Qty.: 25.0000 f(s)/Unit Total : 25.0000 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: M108250

SAD 08/07/09 ①

|     |             |                              |
|-----|-------------|------------------------------|
| 3.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Cut 5 D2235-1 From D3166-1

2- Cut Ribs as per Dwg D2252

3-Drill hole in D2252-1as per Dwg D2252

4-Deburr & Remove all Markings from Material

SAD 08/07/10 ①

|     |        |     |
|-----|--------|-----|
| 4.0 | D22531 | Lug |
|-----|--------|-----|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

|     |             |             |         |
|-----|-------------|-------------|---------|
| Qty | Part Number | Description | Batch   |
| 2   | D2253       | Gusset      | B 35685 |

SAD 08/07/10

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 12:54:05 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET BASE

Job Number: 39779A

Part Number: D2252041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23273

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-3 Bushing B37541

*JS* 08/07/16

6.0

D2581

Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2581 Mounting Chamel B39046

*JS* 08/07/16

7.0

D2254

Gussett



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2254 Lug B23421

*JS* 08/07/16

8.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2232-3 HINGE B39334

*JS* 08/07/16

9.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)

Pick:

Qty Part Number Description Batch

32 sf M304EX0.75-16F Expanded Metal 108474 (256) 108152 (8)

SAD 08/07/14 @

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig Debur as required

A/R SS ROD Batch: M106762

M107051

*JS* 08/07/22

*JS* 08/07/16

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 12:54:05 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET BASE

Job Number: 39779A

Part Number: D2252041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-07-23

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/23 @

13.0

POWDER COATING

POWDER COATING



M108523



(1X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:10 OF  
4:00  
1:40

MF 08/07/23

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

HL 08-07-23 @

15.0

PACKAGING 1

PACKAGING RESOURCE #



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

G-A

EP 08/07/24 @

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/30 @

Job Completion



MF 08-07-30

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

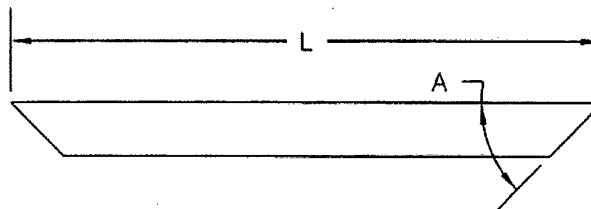
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| DATE<br>05.11.10    |                       | TITLE<br>BASKET ASSEMBLY (206L)  | SCALE<br>NTS           |
| C                   | 95.12.11              | RE-DRAWN   |                        |
| D                   | 99.09.14              | MODIFIED LATCH, D2581 WAS D2255-3  |                        |
| E                   | 05.11.10              | D2253-1 WAS D2253 (NCR 533),<br>ADDED MEMBERS TO LID FRAME,<br>ADDED D2232-1/-3 & D2252-19 |                        |

| Qty<br>-041 | Qty<br>-043 | Part Number | Description            | L     | A  |
|-------------|-------------|-------------|------------------------|-------|----|
| X           |             | D2252-041   | BASKET ASSEMBLY        |       |    |
|             | X           | D2252-043   | LID ASSEMBLY           |       |    |
|             | 2           | D2232-1     | HINGE                  |       |    |
| 2           |             | D2232-3     | HINGE                  |       |    |
| 5           |             | D2235-1     | RIB                    |       |    |
| 2           | 2           | D2252-1     | FRAME                  | 25.50 | 45 |
| 2           |             | D2252-3     | FRAME                  | 96.00 | 45 |
|             | 2           | D2252-7     | FRAME                  | 24.00 | 90 |
| 1           |             | D2252-9     | FRAME                  | 10.25 | 90 |
| 1           |             | D2252-11    | FRAME                  | 25.00 | 90 |
| 1           |             | D2252-13    | FRAME                  | 42.00 | 90 |
| 1           |             | D2252-15    | FRAME                  | 15.00 | 90 |
| 4           |             | D2252-17    | FRAME                  | 19.78 | 53 |
|             | 2           | D2252-19    | FRAME                  | 95.27 | 45 |
|             | 2           | D2252-21    | FRAME                  | 30.82 | 90 |
|             | 1           | D2252-23    | FRAME                  | 30.62 | 90 |
| 2           |             | D2253-1     | LUG                    |       |    |
| 2           |             | D2254       | GUSSET                 |       |    |
|             | 1           | D2327-1     | BUSHING                |       |    |
| 1           |             | D2327-3     | BUSHING                |       |    |
|             | 1           | D2329       | LABEL PLATE            |       |    |
| 4           | 2           | D2581       | MOUNTING CHANNEL       |       |    |
| A/R         | A/R         |             | 3/4-16F EXPANDED METAL |       |    |

**NOTES:**

- 0.065 ~~0.060~~ 08.06.10
- MATERIAL: AISI 304/316 SS 3/4 X 3/4 X (0.060) WALL SQUARE TUBE  
(REF. DART SPEC. M304TS0.750W.060)
  - FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
  - WELD PER DART QSI 004
  - ALL DIMENSION ARE IN INCHES
  - TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

**CUT SIZE DETAIL**

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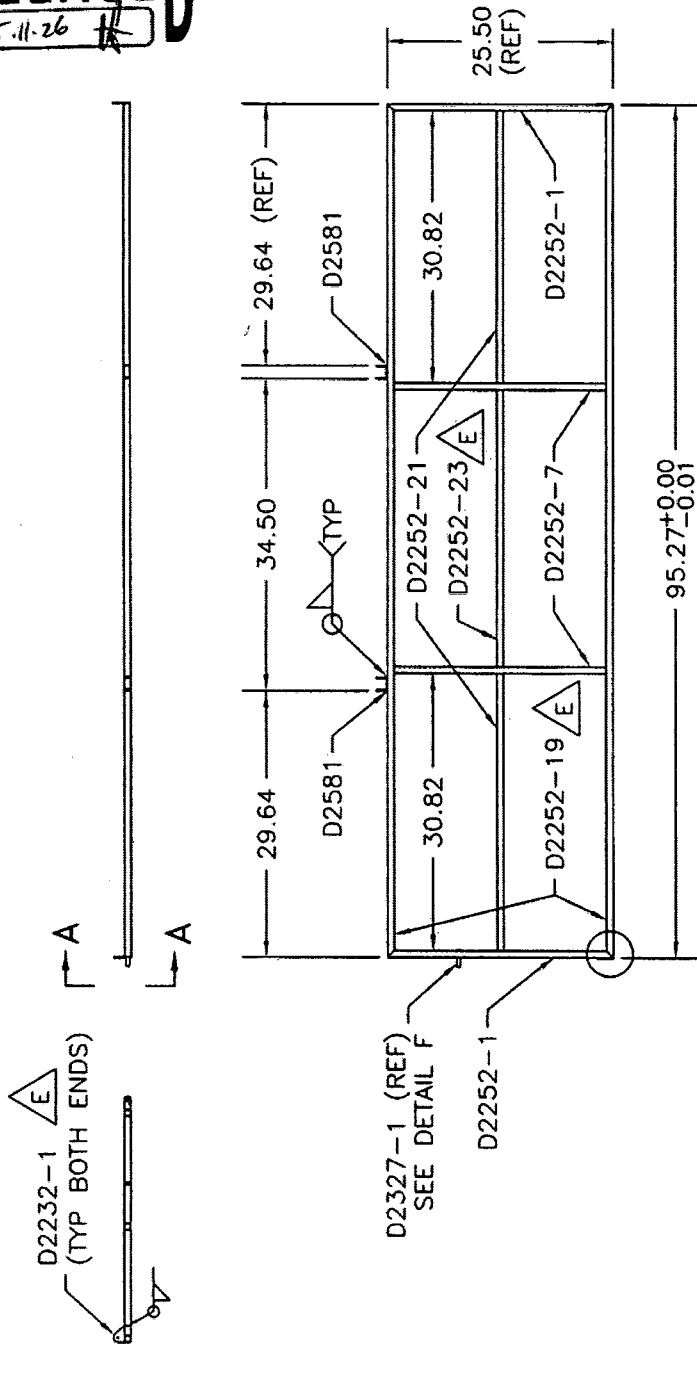
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#1  
01.06.10



D2252-043 LID FRAME

WELD ALL JOINTS  
AS SHOWN

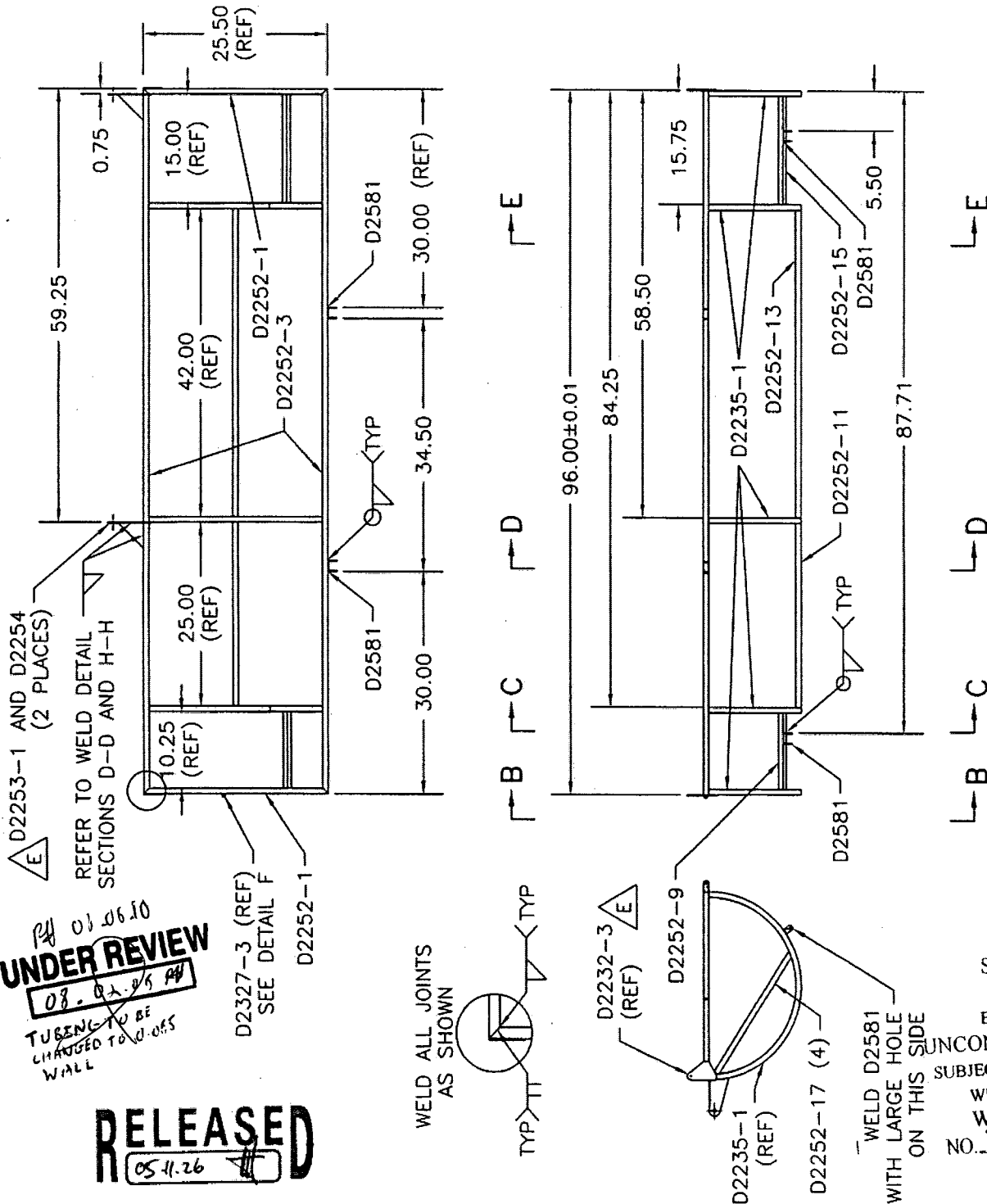
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| DATE<br>05.11.10              | TITLE<br>BASKET ASSEMBLY (206L) |   | SCALE<br>NTS           |



D2252-041 BASKET FRAME

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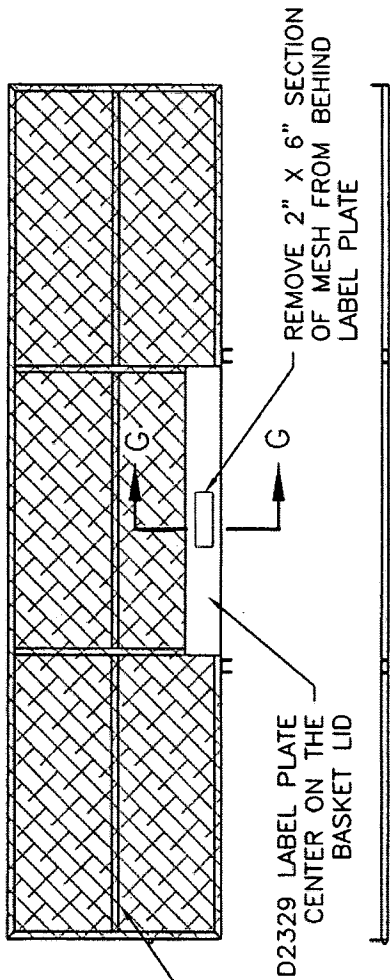
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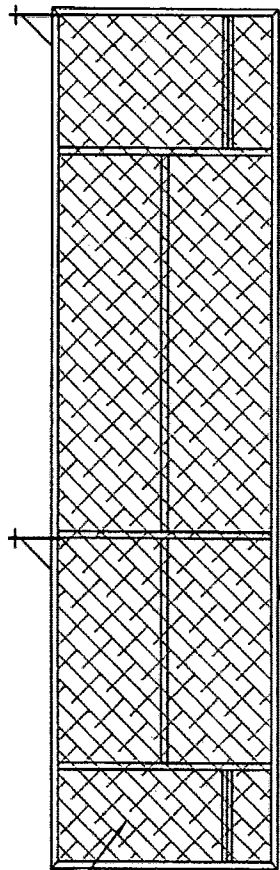
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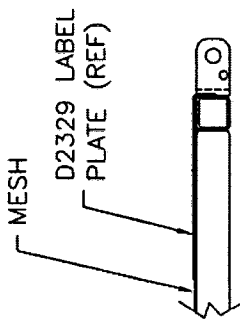
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| DATE<br>05.11.10              | TITLE<br>BASKET ASSEMBLY (206L) |   | SCALE<br>NTS           |



D2252-043 LID ASSEMBLY



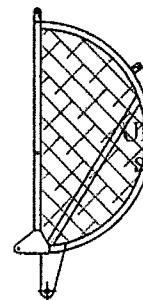
D2252-041 BASKET ASSEMBLY



SKIN WITH 3/4-16 F EXPANDED SS, TACK WELD EACH STRAND END TO FRAME

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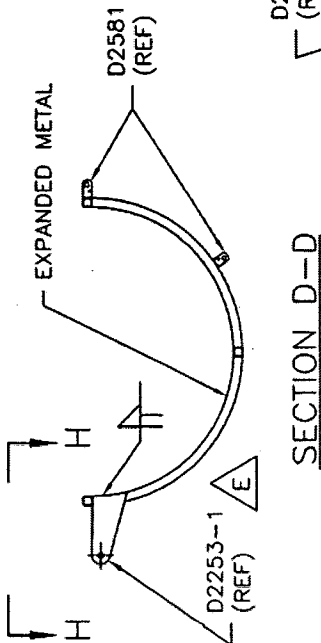
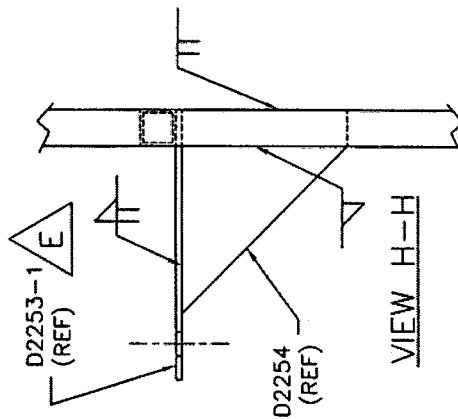
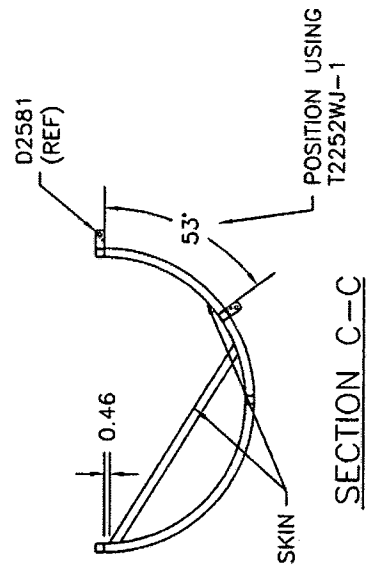
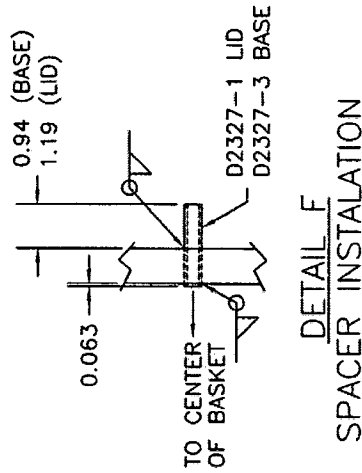
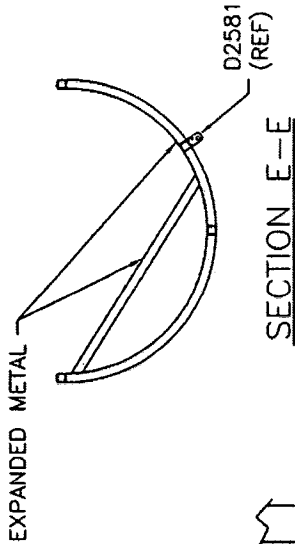
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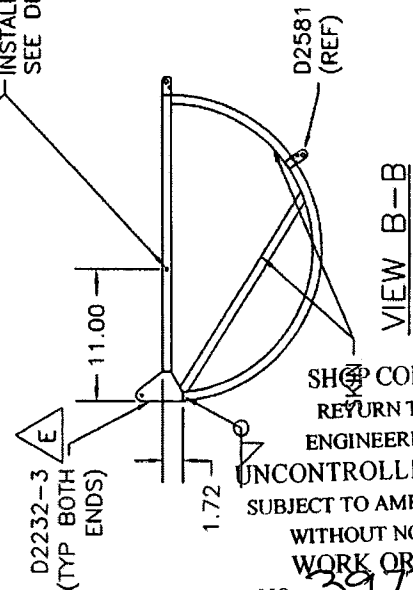
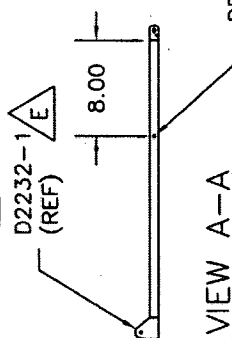
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|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
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| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2252                              | REV. E<br>SHEET 5 OF 5 |
| DATE<br>05.11.10              |                                | TITLE<br>BASKET ASSEMBLY (206L)                   | SCALE<br>NTS           |



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TUBING TO BE  
CHANGED TO 0.065  
WALL

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Date: Tuesday, 10/06/2008 12:54:11 PM  
 User: Julie Lecocq

## Process Sheet

|                                    |   |                           |                 |
|------------------------------------|---|---------------------------|-----------------|
| <b>Customer</b> :                  | CU-DAR001 Dart Helicopters Services         | <b>Drawing Name</b> :     | 206L BASKET LID |
| <b>Job Number</b> :                | 39779B                                      |                           |                 |
| <b>Estimate Number</b> :           | 11274                                       |                           |                 |
| <b>P.O. Number</b> :               |   | <b>Part Number</b> :      | D2252043        |
| <b>This Issue</b> :                | 10/06/2008                                  | <b>S.O. No.</b> :         |                 |
| <b>Prsht Rev.</b> :                | NC  | <b>Drawing Number</b> :   | D2252 REV E     |
| <b>First Issue</b> :               | / /   | <b>Project Number</b> :   | N/A             |
| <b>Previous Run</b> :              | 36655B                                      | <b>Drawing Revision</b> : | E               |
| <b>Written By</b> :                |   | <b>Material</b> :         |                 |
| <b>Checked &amp; Approved By</b> : | JUD 08.6.10                                 | <b>Due Date</b> :         | 30/06/2008      |
| <b>Comment</b> :                   | Est Rev:1 REVISED AS PER REV E 05-12-06 JLM |                           |                 |

Qty: 1 Um: Each

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |                |                          |
|-----|----------------|--------------------------|
| 1.0 | M304TS0750W065 | 304 SQ Tube.75x.75x.065W |
|-----|----------------|--------------------------|



0.065 W 01.06.10



Comment: Qty.: 32.5539 f(s)/Unit Total : 32.5539 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: M108250

SAD 08/07/10

①

|     |             |                              |
|-----|-------------|------------------------------|
| 2.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1- Cut D2252-1-3-9 as per Dwg D2252

SAD

08/07/10

①

2-Drill hole in D2252-1 as per Dwg D2252

3-Deburr & Remove all Markings from Material

|     |       |             |
|-----|-------|-------------|
| 3.0 | D2329 | Label Plate |
|-----|-------|-------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2329

Label Plate

B35686

SAD 08/07/22

|     |        |                |
|-----|--------|----------------|
| 4.0 | D23271 | Spacer Bushing |
|-----|--------|----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2327-1

Bushing

B40084

SAD 08/07/21

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Tuesday, 10/06/2008 12:54:11 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET LID

Job Number: 39779B

Part Number: D2252043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

HINGE

B39454

JS 08/07/21

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Chancel

B39046

JS 08/07/21

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s)

Pick:

Qty Part Number

Description

Batch

18 sf M304EX0.75-16F Expanded Metal

108474

SAP 08/07/14 D

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig

Deburr as required

A/R SS ROD

Batch: M107051

JS 08/07/22

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-07-23

10.0

QC5

INSPECT WORK TO CURRENT STEP



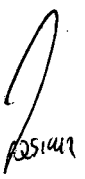
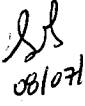



Comment: INSPECT WORK TO CURRENT STEP

SOB 08/07/23

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D2252-043 PAR #: N/A Fault Category: Prod / Ins. Large NCR: Yes No DQA: D Date: 08/07/22  
 QA: N/C Closed: D Date: 08/07/22

| NCR: <u>39779 B</u> |      | WORK ORDER NON-CONFORMANCE (NCR)  |  |   |   |  |  |  |
|---------------------|------|---|--|---|---|--|--|--|
| DATE                | STEP | Description of NC<br>Section A  | Corrective Action Section B  |   |   | Verification<br>Section C  | Approval<br>Chief Eng  | Approval<br>QC Inspector   |
|                     |      |   | Initial<br>Chief Eng   | Action Description<br>Chief Eng   | Sign &<br>Date  |  |  |  |
| 08/07/22            | B.O  | After welding lid from welder notices that he has two D23271 Bushings (Basket only needs 1).<br>R.C. under <del>two</del> <u>one</u> D2252-1 each with the hole for the D23271 Bushings. He didn't pay attention and welded the bushings in place. What did not pay attention to DWG. |  | <ul style="list-style-type: none"> <li>Remove bushing.</li> <li>drill a tiny hole @ the end of the lid to remove any foreign objects.</li> <li>Fill holes with weld per QSI 004 Rod m <u>M1007051</u> A/R.</li> <li>grind flush.</li> <li>Ensure to verify the Dwg: Assembly to the parts being used..</li> </ul> | <br>08/07/22 | <br>08/07/22 | <br>08/07/22 | <br>08/07/22 |
|                     |      |   |  |   |   |  |  |  |
|                     |      |   |  |   |   |  |  |  |

NOTE: Date & initial all entries



Date: Tuesday, 10/06/2008 12:54:12 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET LID

Job Number: 39779B

Part Number: D2252043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

POWDER COATING

POWDER COATING



N/108523



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:10  
4:00  
1:40

M-L 08/07/23

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SL 08-07-23

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 6-A

EP 08/07/24

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/30

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-07-30

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

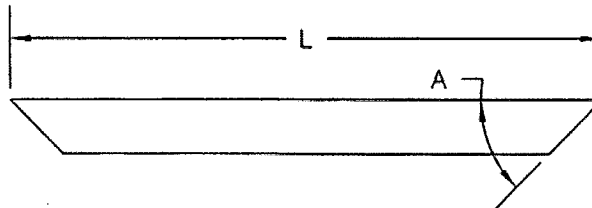
**DART****RELEASED**  
05.11.26

|                     |                       |  |                        |
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| CHECKED<br><b>#</b> | APPROVED<br><b>#</b>  | DRAWING NO.<br>D2252   | REV. E<br>SHEET 1 OF 5 |
| DATE<br>05.11.10    |                       | TITLE<br>BASKET ASSEMBLY (206L)  | SCALE<br>NTS           |
| C                   | 95.12.11              | RE-DRAWN   |                        |
| D                   | 99.09.14              | MODIFIED LATCH, D2581 WAS D2255-3  |                        |
| E                   | 05.11.10              | D2253-1 WAS D2253 (NCR 533),<br>ADDED MEMBERS TO LID FRAME,<br>ADDED D2232-1/-3 & D2252-19 |                        |

| Qty<br>-041 | Qty<br>-043 | Part Number | Description            | L     | A  |
|-------------|-------------|-------------|------------------------|-------|----|
| X           |             | D2252-041   | BASKET ASSEMBLY        |       |    |
|             | X           | D2252-043   | LID ASSEMBLY           |       |    |
|             | 2           | D2232-1     | HINGE                  |       |    |
| 2           |             | D2232-3     | HINGE                  |       |    |
| 5           |             | D2235-1     | RIB                    |       |    |
| 2           | 2           | D2252-1     | FRAME                  | 25.50 | 45 |
| 2           |             | D2252-3     | FRAME                  | 96.00 | 45 |
|             | 2           | D2252-7     | FRAME                  | 24.00 | 90 |
| 1           |             | D2252-9     | FRAME                  | 10.25 | 90 |
| 1           |             | D2252-11    | FRAME                  | 25.00 | 90 |
| 1           |             | D2252-13    | FRAME                  | 42.00 | 90 |
| 1           |             | D2252-15    | FRAME                  | 15.00 | 90 |
| 4           |             | D2252-17    | FRAME                  | 19.78 | 53 |
|             | 2           | D2252-19    | FRAME                  | 95.27 | 45 |
|             | 2           | D2252-21    | FRAME                  | 30.82 | 90 |
|             | 1           | D2252-23    | FRAME                  | 30.62 | 90 |
| 2           |             | D2253-1     | LUG                    |       |    |
| 2           |             | D2254       | GUSSET                 |       |    |
|             | 1           | D2327-1     | BUSHING                |       |    |
| 1           |             | D2327-3     | BUSHING                |       |    |
|             | 1           | D2329       | LABEL PLATE            |       |    |
| 4           | 2           | D2581       | MOUNTING CHANNEL       |       |    |
| A/R         | A/R         |             | 3/4-16F EXPANDED METAL |       |    |

**NOTES:**

- MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE  
(REF. DART SPEC. M304TS0.750W.060)
- FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- WELD PER DART QSI 004
- ALL DIMENSION ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

**CUT SIZE DETAIL**

0.065 **PH** 01.06.10  
**UNDER REVIEW**  
08/02/05 **PH**  
TUBING TO BE  
CHANGED TO 0.065  
WALL RETURN TO  
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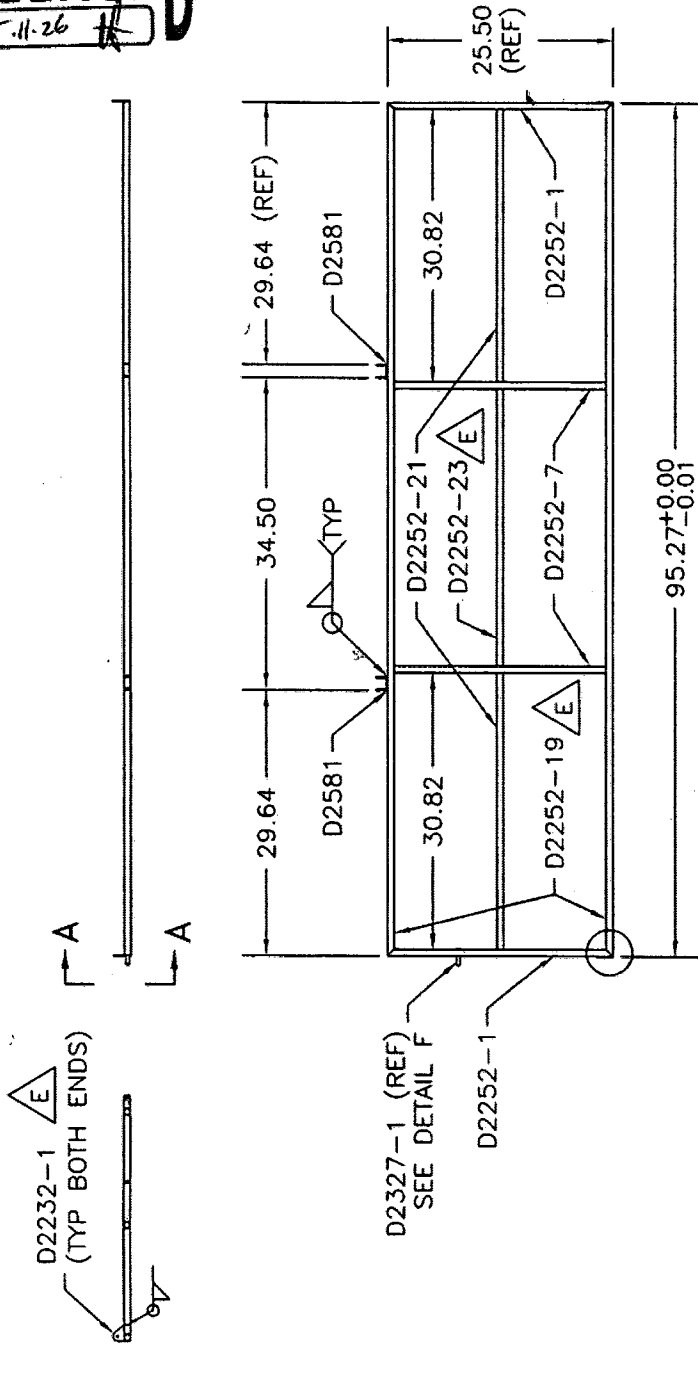
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| DATE<br>05.11.10              |                                | TITLE<br>BASKET ASSEMBLY (206L)                   | SCALE<br>NTS           |

**RELEASED**  
05.11.26 *[Signature]*

**UNDER REVIEW**  
08.01.06 *[Signature]*

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WALL  
*[Signature]*  
06.06.10



D2252-043 LID FRAME

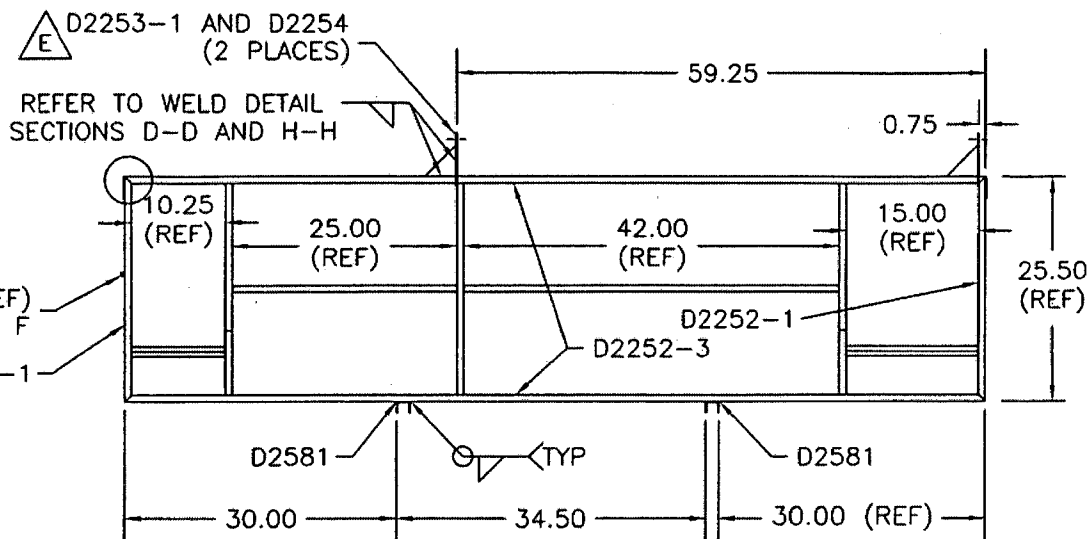
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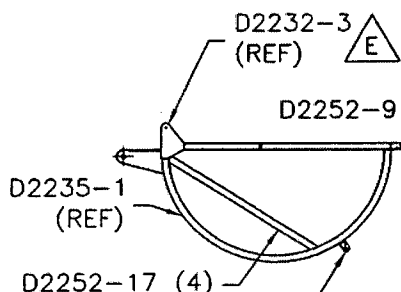
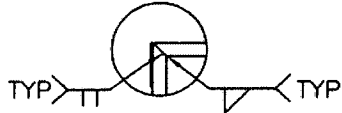
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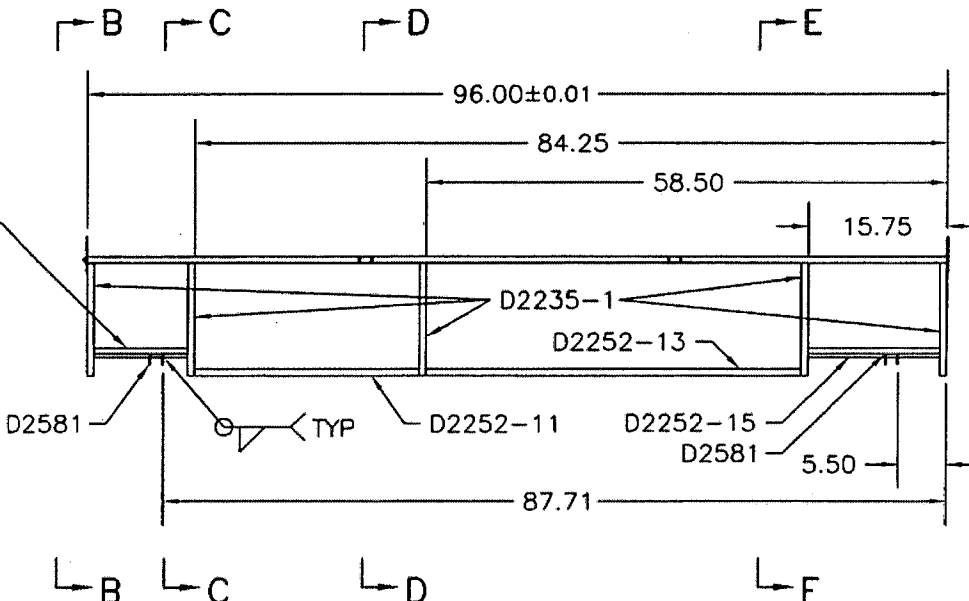
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| DATE    | 05.11.10           | TITLE    | D2252              | REV. E                      |
|         |                    |          |                    | SHEET 3 OF 5                |
|         |                    |          |                    | SCALE                       |
|         |                    |          |                    | NIS                         |



WELD ALL JOINTS  
AS SHOWN



WELD D2581  
WITH LARGE HOLE  
ON THIS SIDE



D2252-041 BASKET FRAME

**UNDER REVIEW**  
08.02.05  
TUBING TO BE  
CHANGED TO 0.065  
WALL

**RELEASED**  
05.11.26

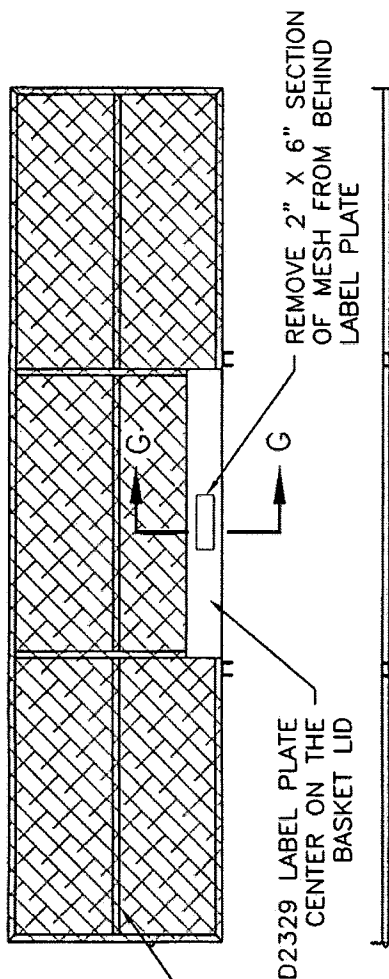
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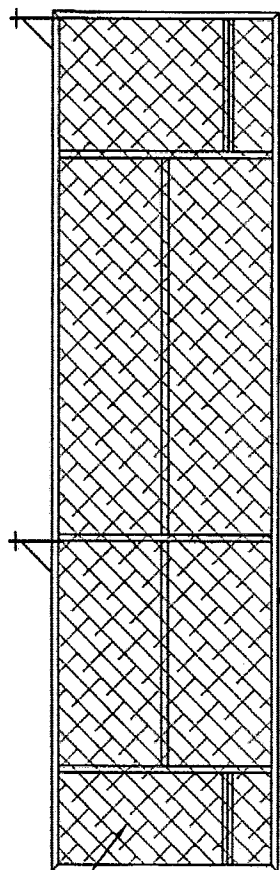
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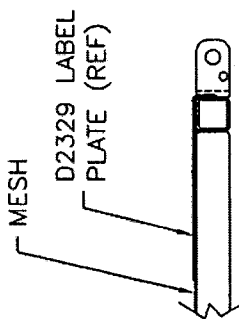
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| DATE    | 05.11.10           |          |                    | TITLE<br>BASKET ASSEMBLY (206L)                   | SCALE<br>NTS           |



D2252-043 LID ASSEMBLY



D2252-041 BASKET ASSEMBLY



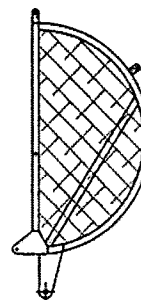
SECTION G-G



SKIN WITH 3/4-16 F  
EXPANDED SS, TACK  
WELD EACH STRAND  
END TO FRAME

*[Signature]* 06.06.10  
**UNDER REVIEW**  
08.01.05 *[Signature]*  
TUBING TO BE  
CHANGED TO 0-085  
WALL

**RELEASED**  
05.11.26 *[Signature]*



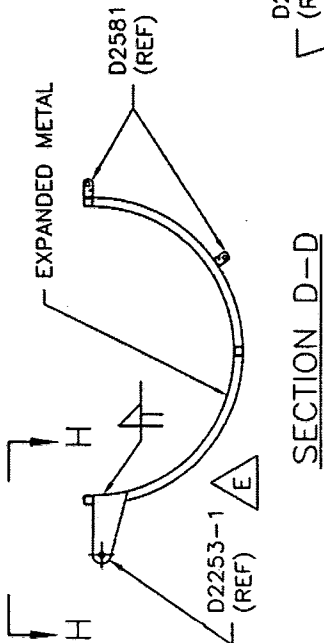
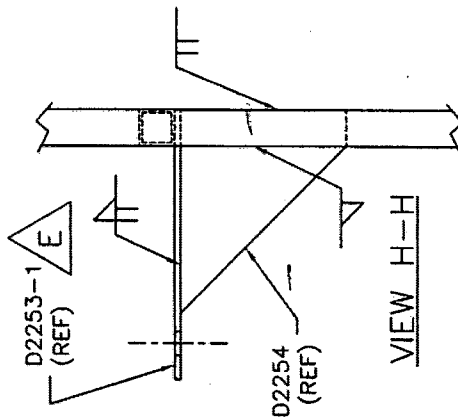
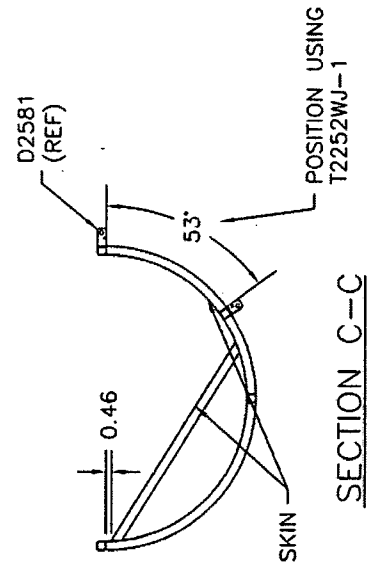
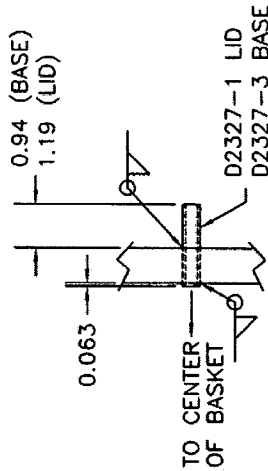
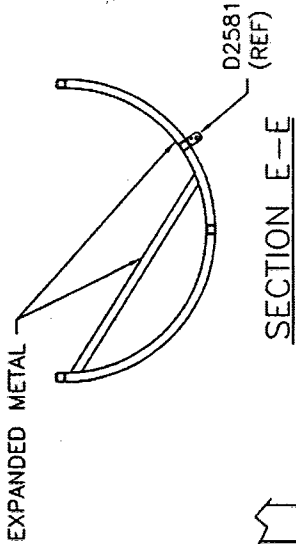
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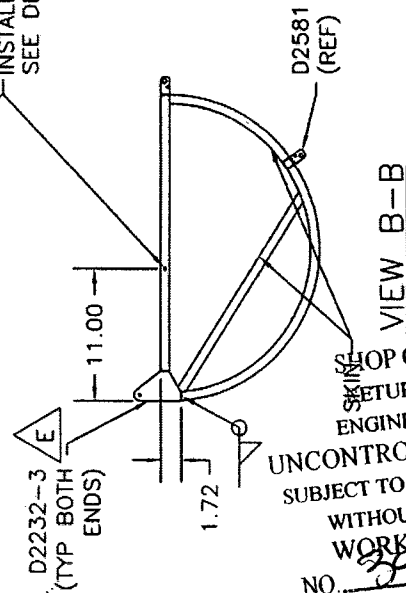
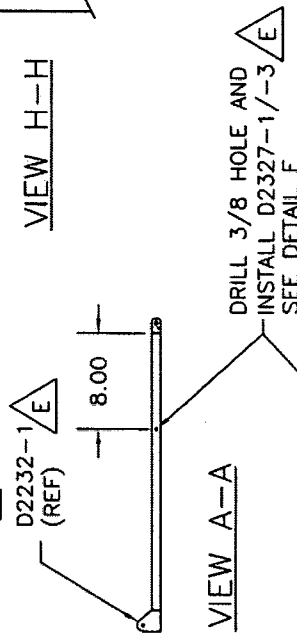
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|                               |                                 |   |                        |
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| DATE<br>05.11.10              | TITLE<br>BASKET ASSEMBLY (206L) |   | SCALE<br>NTS           |



06.06.10  
**UNDER REVIEW**  
08.02.05  
TUBING TO BE  
CHANGED TO 0.065  
WALL

**RELEASED**  
05.11.26



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